



Date: Thursday, 3/8/2007 12:32:26 PM
User: Kim Johnston

Process Sheet



Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 SKIDTUBE "I" BEAM
Job Number	: 31110		
Estimate Number	: 10346		
P.O. Number	: N/A	Part Number	: D2596
This Issue	: 3/8/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2596 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 29724	Drawing Revision	: C
		Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 3/21/2007
Checked & Approved By	: <u>[Signature]</u> 07.03.08	Qty:	4 Um: Each
Comment	: Est: D-99.02.02 Changed QA to QC, Added Step 6 and Cost D M		

Additional Product

Job Number:	
-------------	---

Seq. #:	Machine Or Operation:	Description:
1.0	D25003100	Ext'n -I' Beam Web 4"
		



Comment:	Qty.: 1.0000 Each(s)/Unit	Total: 4.0000 Each(s)
	Extrusion "I" Beam Web 4"	
Pick;		
Qty	Part Number	Description
1	D2500-3-100	Extrusion
	Batch	<u>B 25751 JB 7-3-12 (4)</u>

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
		



Comment:	LANDING GEAR RESOURCE 1
	1- Cut D2500-3-100 to length: 99.5"
	2- Use Jig DT8093 to drill pilot holes #30
	3- Open to 0.630" diameter as per Dwg D2596
	4- Deburr
	<u>JB 7-3-12</u>

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		

Comment:	HAND FINISHING RESOURCE #1
	Acid Etch and Alodine per QSI 005 4.1
	<u>JB 7-3-12</u>

4.0	QC5	INSPECT WORK TO CURRENT STEP
		

Comment:	INSPECT WORK TO CURRENT STEP
	<u>DP 7-3-12 (4)</u>

5.0	PACKAGING 1	PACKAGING RESOURCE #1
		

Comment:	PACKAGING RESOURCE #1
	Identify and Stock
	Location: <u>LG</u>
	<u>JB 7-3-12</u>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 10 Date: 07/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 12:32:27 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 31110

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

2. 07.03.13

Job Completion



4. 07.03.13

No

No

No

No

No

No

No

No

No

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

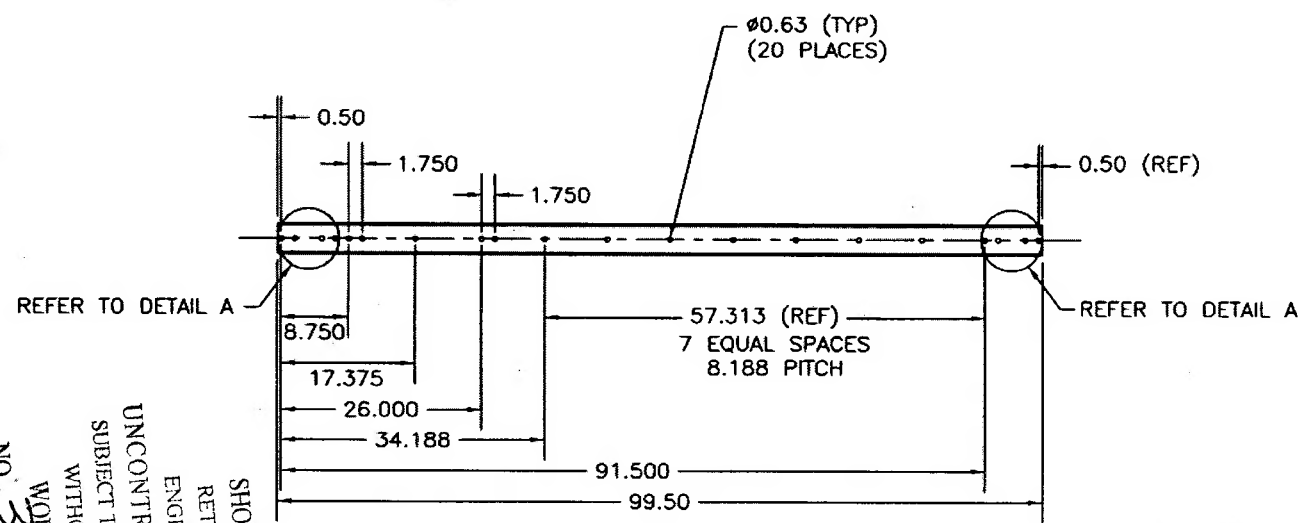
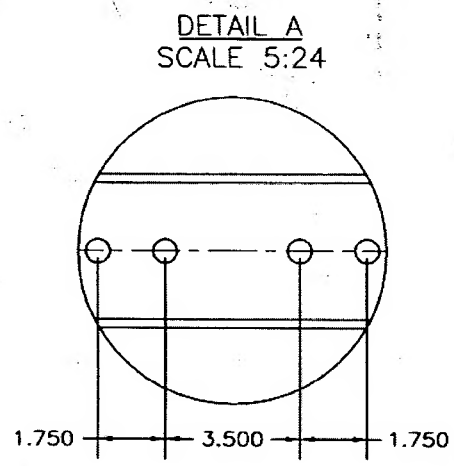
NOTE: Date & initial all entries

DART



RELEASED
98.09.17 DS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2596
DATE 98.09.14	TITLE 205 WEB	REV. C SHEET 1 OF 1
A	96.09.16	NEW ISSUE
B	97.07.23	Ø0.63 HOLE WAS Ø0.56
C	98.09.14	INCORPORATED DEO 9097



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 31110
WORK ORDER

MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED